

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020618**Date Inspected:** 11-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Geng Wei		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 07734. The member(s) is/are identified as Floor Beam to Bottom Plate. The weld designations reviewed are as follows:

SEG3013F-002/001

SEG3013AU-075, 076, 079, 080

SEG3013AV-073, 075

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SEG3013L-001

SEG3013K-002

SEG3013N-026

SEG3013AQ-150/160

SEG3013M-260/219

SEG3013AX-100/104

OBG BAY 14

This QA Inspector observed the following work in progress:

During random in process inspection of Orthotropic Box Girder (OBG) member identified as DP3104-001 weld number(s) 248 this QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate to Deck Plate identified as noted above. Welder is identified as welder no. 044830. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-FCAW-2G-(2F)-ESAB REPAIR and B-CWR2400.

During random in process inspection of Orthotropic Box Girder (OBG) member identified as DP3104-001 weld number(s) 152 this QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate to Deck Plate identified as noted above. Welder is identified as welder no. 044830. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-FCAW-2G-(2F)-ESAB REPAIR and B-CWR2400.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As mentioned above between QA and QC concerning this project

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert
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Quality Assurance Inspector

Reviewed By:	Riley,Ken
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QA Reviewer
